

SWS

Dart Aerospace Ltd.

Date: Wednesday, 15/08/2007 4:00:48 PM
User: Linda Lacelle

Process Sheet

SP 107

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33950
Estimate Number : 11261
P.C. Number : N/A
This Issue : 15/08/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 33376
Written By :
Checked & Approved By :
Comment : Est. A 03.09.13 New issue KJ/JLM

Drawing Name : LUG
Part Number : D34143
Drawing Number : D3414
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 31/08/2007

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304B0500X2500 304 BAR



Comment: Qty.: 0.1969 f(s)/Unit Total: 5.9063 f(s)
304 BAR
Material: 304/316 SS Bar
(M304B0.500x02.500)
Identify for D3414-3
Batch: M18929

Note



2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks: 2.50" x 0.500" x 2.250" long



3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA569 and Dwg D3414
Identify as D3414-3Dwg Rev. Folio Rev.

Machine per drawing D3414

SA 07.08.17
Meter 0207/08/20 (73)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + inspect for transit damage



5.0 QC5 SECOND CHECK



Comment: SECOND CHECK - inspect level 5

SA 07/09/07 (73)
counter
SA 01/09/07 (73)

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Drawing Name: LUG

Job Number: 33950

Part Number: D34143

Job Number



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

73
107/09/10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

73
107/09/10

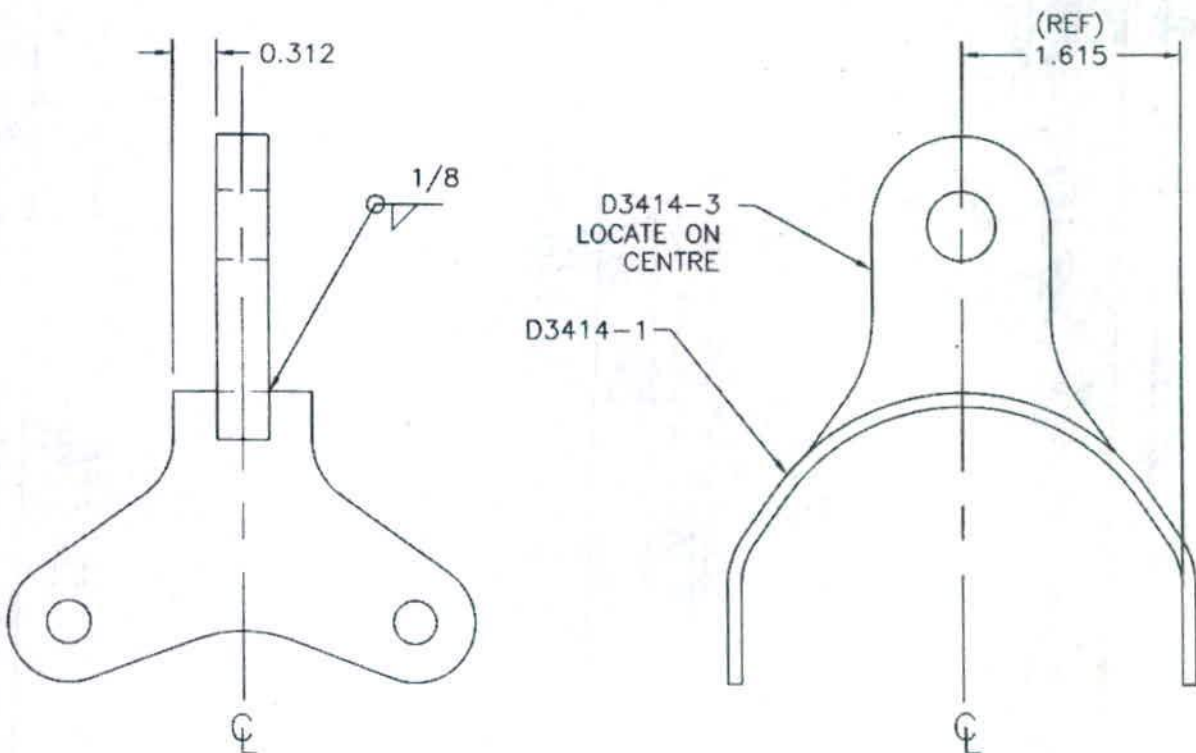
Job Completion:



U 07-09-10

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.16	DRAWING NO.	D3414	REV. A
		TITLE	LUG ASSEMBLY	SHEET 1 OF 3
			NEW ISSUE	SCALE
				NTS

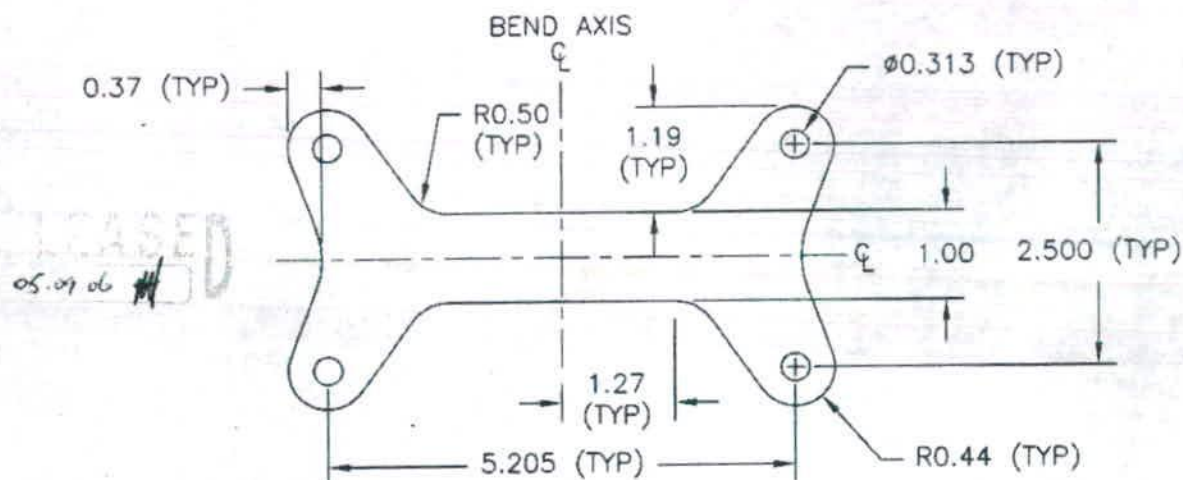


D3414-041 LUG ASSEMBLY

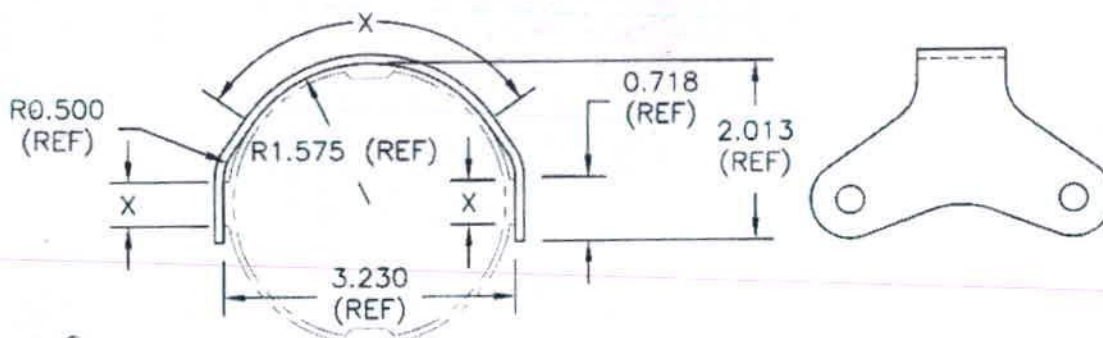
- 1) WELD PER DART QSI 004
 - 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) PART IS SYMMETRIC ABOUT CENTERLINE
- WLB 33950*

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2



D3414-1 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D3414-1 BEND DETAIL

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

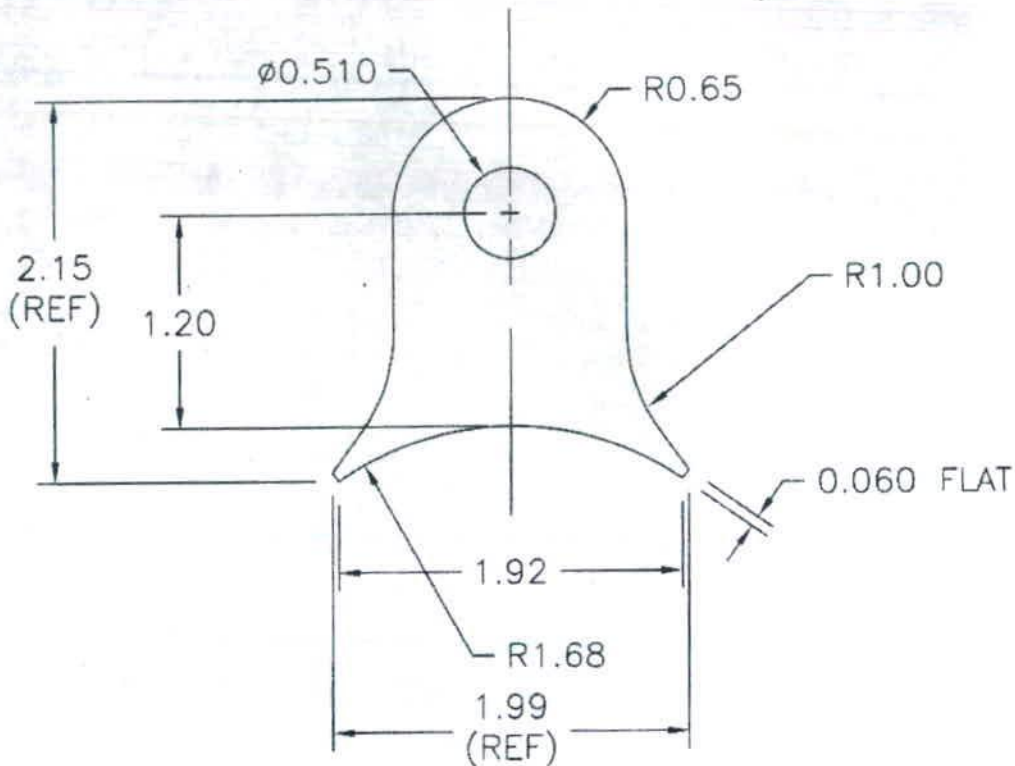
- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:1

**D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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REÇU DE LIVRAISON - DELIVERY RECEIPT

METEC-METAL TECHNOLOGY INC.

VANKLEEK HILL, ON K0B 1R0

metec@metec.ca

www.metec.ca

211861

DATE *Sept. 07, 2007*

VOTRE N° DE COMMANDE
YOUR ORDER NO.

DE
FROM

A
TO *Dart*

ADRESSE
ADDRESS *H'bury*

VILLE
CITY

COLIS
PACKAGES

REÇU EN BON ETAT
RECEIVED IN GOOD CONDITION

POIDS
WEIGHT

73 x Lug D3414-3 in Stainless

P.O. 4404

Ep 507/08/07

Thank you

(20x 10kg Aug. 31, 2007)

REÇU PAR
RECEIVED BY

NOMBRE DE COLIS
NUMBER OF
PACKAGES

POIDS TOTAL
TOTAL WEIGHT

C.R.
COD

FRAIS DE LIVRAISON
DELIVERY CHARGE

Blueline DCB56

**CERTIFICATE OF CONFORMITY**

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

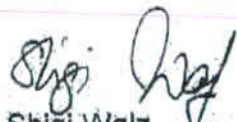
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
73	D3414-3	Lug MATERIAL: supplied by DART	4404
20	D3394-3	Lug MATERIAL: supplied by DART D2423 B33310	4404

on
H02/07

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, September 7, 2007

